

Split

Work Order ID 75055-1

75055

Page 1

Item ID: D3296-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Door Assembly

Start Date: 17/10/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 28/10/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: M.L.5

Date: 11/10/17 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320°F

9:45

M 11/5/28

9/5/11/28 (10)

M 11 11 28 (10)

10X Ø m-1 11/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75055

October-17-11 10:40:08 AM

75055

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Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 17/10/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3296								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

10 11-11-30

EP 11/12/01 (10)

11 12 01 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3296-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Assembly
 Start Date: 17/10/2011 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 28/10/2011 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: _____	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

11/12/11 (10)

11/12/11

MF 11-12-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 75055

75055

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C05,10,14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	14.0000	1	10			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				14					
				72725				6					
				74609				8					
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	14.0000	1	10			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST037				14					
				72726				8					
				74610				6					
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	20.0000	1	10			
									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST186				20					
				71719				4					
				74614				16					

Handwritten notes and signatures:

- Signature: *EP 11/11/28*
- Text: *B76938*
- Text: *42*
- Signature: *EP 11/11/28*
- Text: *B76939*
- Text: *42*
- Signature: *EP 11/11/23*
- Text: *10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75055

75055

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

D3296-3

Manufactured No

100

Each

24.0000

1

10

D3296-3

Door Panel

**

Location

Loc Qty

Loc Code

ST186

16

74615

16

ST196

8

71717

8

MS20470AD4-6

Purchased No

100

Each

2,509.000

1

10

MS20470AD4-6

Rivet, Universal Head

**

Location

Loc Qty

Loc Code

ST319

1509

117395

68

117887

8

118927

1433

ST320

1000

119109

1000

D2137

Manufactured No

140

Each

24.0000

1

10

D2137

Decal - No Step

**

Location

Loc Qty

Loc Code

GA

10

74029

10

ST006

14

72053

14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75055

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Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

D2419 Manufactured No

140 Each 16.0000 1 10

D2419

Handle

**

Location

Loc Qty

Loc Code

GA

16

69732

4

74514

12

D2462 Manufactured No

140 f 455.8674 0.3333 3.333

D2462

Seal

**

Location

Loc Qty

Loc Code

ST404

455.8674

48530

455.8674

D2728-1 Manufactured No

140 Each 0.0000 0 0

D2728-1

Dart Logo label

MS20470AD4-4

Purchased No

140 Each 4,190.000 25 250

MS20470AD4-4

Rivet, Universal Head

**

**

Location

Loc Qty

Loc Code

ST139

78

117423

78

ST319

4112

116188

136

116391

66

118614

1910

119109

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 75055

75055

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 17/10/2011

Required Date: 28/10/2011

Start Qty: 10.00

Required Qty: 10.00

NAS1149DN632J

Purchased

No

140

Each

795.0000

I

10

NAS1149DN632.I

**

Washer

Location

Loc Qty

Loc Code

ST297

795

118428

795

EB 11/12/01
10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

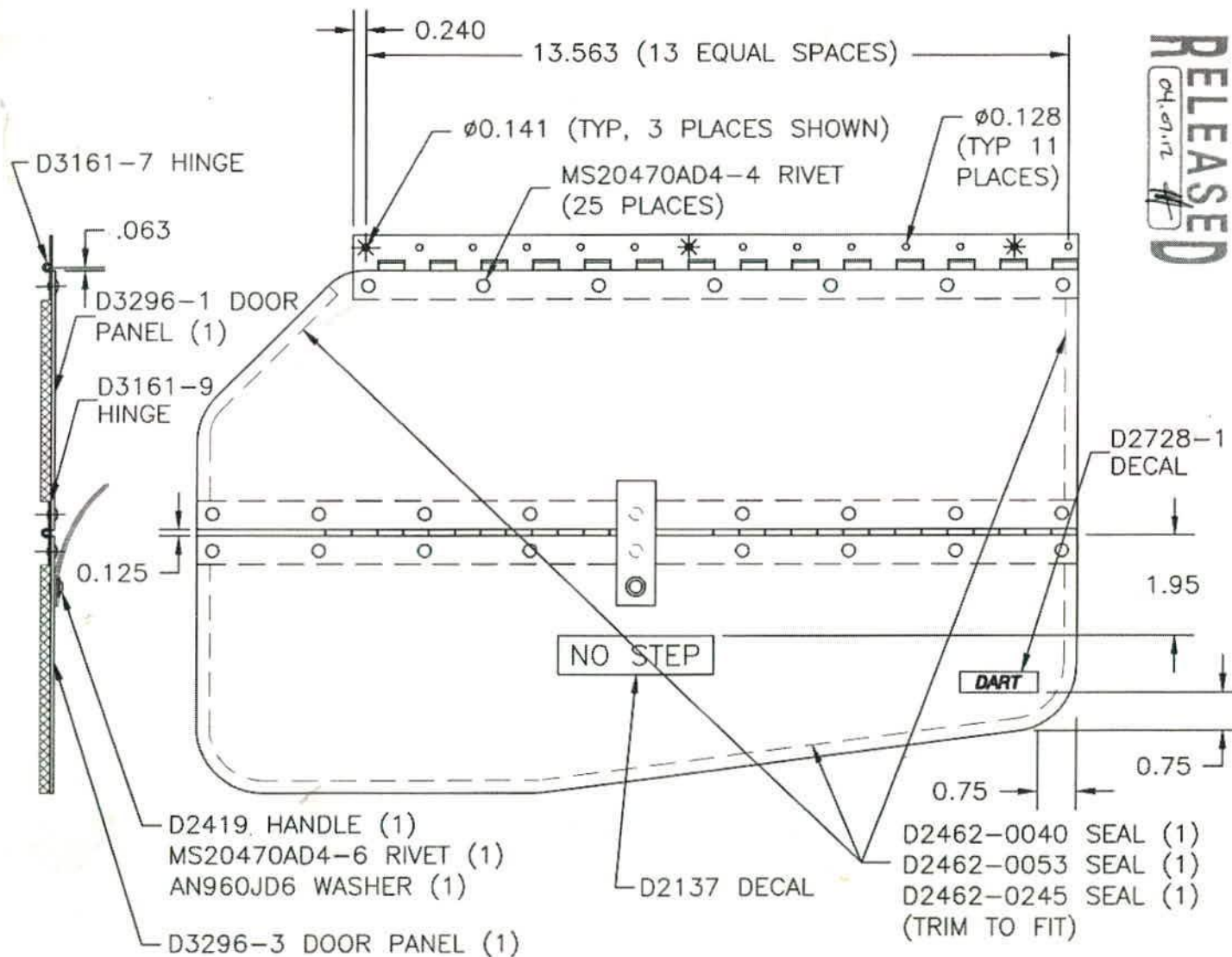
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

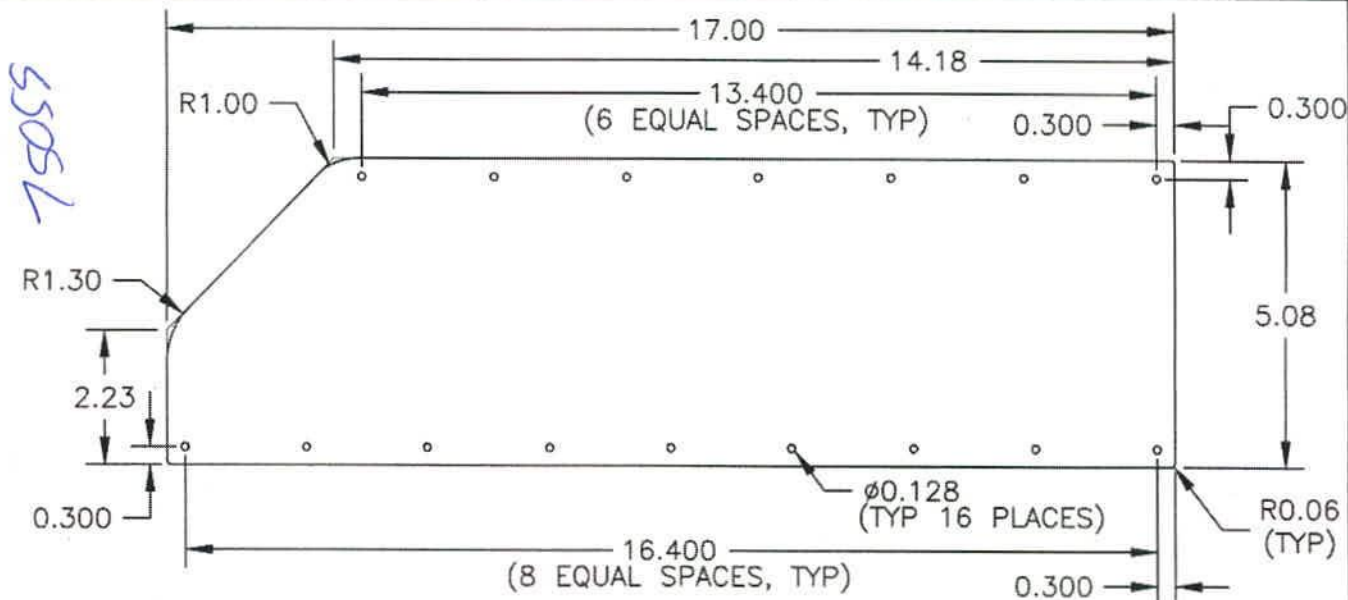
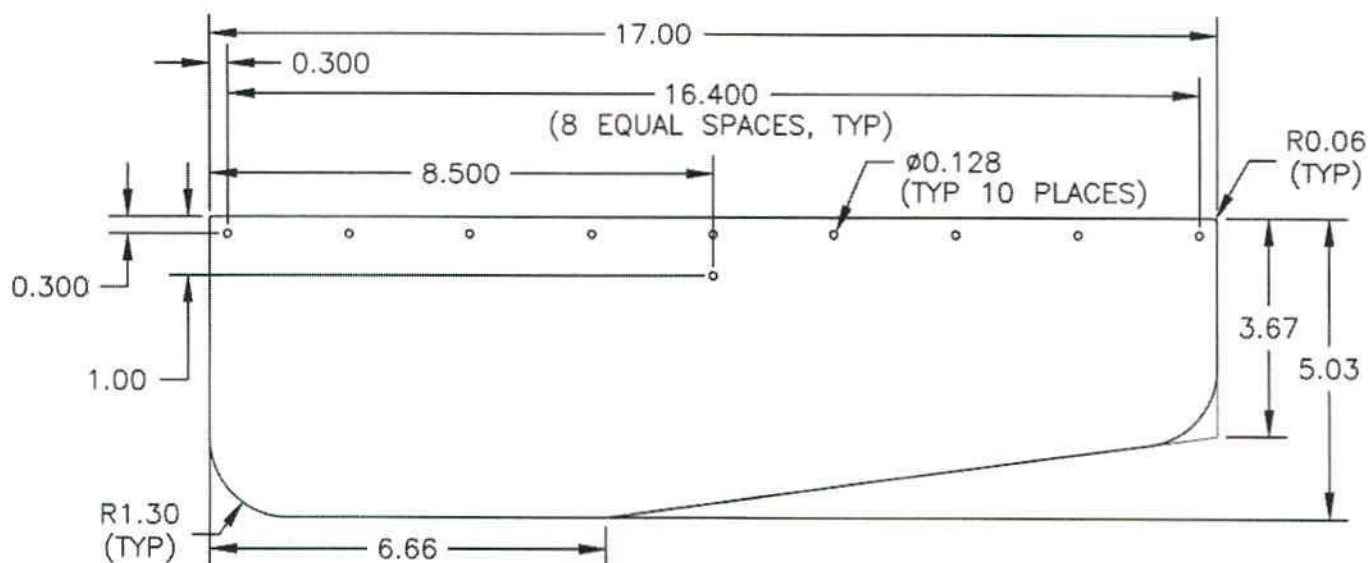
SHOP COPY
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK
NO. 220



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. A
04.06.28	D3296	1 OF 2
A	DOOR ASSEMBLY	SCALE
04.06.28	NEW ISSUE	1:3

DART

DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3

**D3296-1 DOOR PANEL****D3296-3 DOOR PANEL****D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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